

State of Illinois
Department of Transportation
Bureau of Materials and Physical Research

POLICY MEMORANDUM

January 15, 2002	Springfield	02-01
------------------	-------------	-------

TO: DISTRICT ENGINEERS AND HIGHWAY BUREAU CHIEFS

SUBJECT: APPROVAL OF CONCRETE PLANTS AND DELIVERY TRUCKS

DEFINITIONS

Commercial Concrete Producer - A company engaged in the production of concrete.

Contractor - The individual, firm, partnership, joint venture, or corporation contracting with Department for performance of prescribed work.

Department - Illinois Department of Transportation

District - One of nine Illinois Department of Transportation highway districts located throughout the State of Illinois.

1.0 PURPOSE

- 1.1 To establish a uniform procedure, for all Districts, to approve a concrete plant [Article 1103.02 of the *Standard Specifications for Road and Bridge Construction* (January 1, 2002)] and delivery trucks before production begins.

To ensure the concrete plant and delivery trucks are maintained according to Department specifications, with minimal District inspection.

To establish a concrete plant equipment database.

2.0 APPLICATION FOR APPROVAL

- 2.1 To obtain approval for a concrete plant the Contractor or Commercial Concrete Producer shall provide the following:
- A completed "Concrete Plant Survey" form (Attachment A). The form is submitted once every five years, unless the plant equipment is changed, or equipment is added to the plant.

- A completed "Inspection Certification for Concrete Plant" form (Attachment B). The form is submitted annually, for the period which begins April 1st, and which expires the following year on March 31st.
- 2.2 To obtain approval for concrete delivery trucks, the Contractor or Commercial Concrete Producer shall provide the following:
- A completed "Inspection Certification for Concrete Delivery Trucks" form (Attachment C). The form is submitted annually, for the period which begins April 1st, and which expires the following year on March 31st.
- 2.3 The Contractor or Commercial Concrete Producer shall submit the forms to the District in which the concrete plant or delivery trucks are located, or the nearest District if the concrete plants or trucks are located out of state.

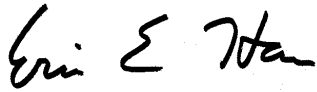
3.0 DEPARTMENT APPROVAL

Prior to approval, the District will review the completed forms, observe the calibration of the plant scales, inspect the concrete plant, and inspect the delivery trucks. The extent of the plant and truck equipment inspection will be determined by the District.

Upon approval, the Contractor or Commercial Concrete Producer will be notified in writing by the District.

4.0 RENEWAL OF APPROVAL

- 4.1 The Contractor or Commercial Concrete Producer shall resubmit the forms as indicated in **Section 2.0**. Re-approval will be according to **Section 3.0**.



Eric E. Harm, P.E.
Engineer of Materials
and Physical Research

Attachments

This policy memorandum supersedes Policy Memorandum 99-10 dated November 15, 1999.
--

| RWH/dg

ILLINOIS DEPARTMENT OF TRANSPORTATION CONCRETE PLANT SURVEY

Effective: March 1, 1997 --- Revised: January 1, 2002

Instructions: **Please type or print neatly.** Fill in the blanks or mark the item with an "X". The "Concrete Plant Survey" is submitted once every five years, unless the plant equipment is changed, or equipment is added to the plant.

Producer No.: _____ Plant Name: _____ Permanent: _____ Portable: _____

Company Address: _____ Phone No.: _____

Plant Address: _____ Phone No.: _____
(Indicate "Various" if Portable Plant)

Plant Manufacturer: _____ Model # _____ Serial # _____

Indicate Plant Type Below:

Wet Batch Plant (Stationary-Mixed / Central-Mixed): _____

Mixer Capacity: (Cubic Meters) _____ (Cubic Yards) _____ * Type _____

Mixer Capacity: (Cubic Meters) _____ (Cubic Yards) _____ * Type _____

* Indicate: Non-Tilting; Tilting; Vertical Shaft; or Horizontal Shaft

Dry Batch Plant (Truck-Mixed / Transit-Mixed): _____

Capacity as Determined by the Weigh Hopper: (Cubic Meters) _____ (Cubic Yards) _____

Capacity as Determined by the Weigh Hopper: (Cubic Meters) _____ (Cubic Yards) _____

Slurry Mixer Type: Vortex _____ Paddle _____ None _____

Batching System Manufacturer: _____

Batching System Type:

** Automatic _____ ** Semi-Automatic _____ ** Manual _____

** Reference: Article 1103.03 of Standard Specifications for Road and Bridge Construction (January 1, 2002)

Automatic Actuation: Computer _____ Punch Card _____ Step Switch _____

*** Material(s)	Scale Capacity for Weighing (Do not consider Weigh Hopper) (kg / lbs.)	Scale Graduation Interval (kg / lbs.)	Scale Graduation Interval (Percent of Scale Capacity)	**** Scale Type
_____	_____/____	_____/____	_____	_____
_____	_____/____	_____/____	_____	_____
_____	_____/____	_____/____	_____	_____
_____	_____/____	_____/____	_____	_____
_____	_____/____	_____/____	_____	_____
_____	_____/____	_____/____	_____	_____

*** Indicate the material(s) weighed by each scale. This should include Fine Aggregate, Coarse Aggregate, Cement, Finely Divided Minerals, Water, and Admixtures.

**** Indicate: Beam; Dial; or Load Cell

Weighing of Aggregates in Weigh Hopper: Individually _____ Cumulatively _____

Weighing of Cement and Cementitious Materials in Weigh Hopper: Individually _____ Cumulatively _____

Number of Silos: Cement _____ Fly Ash _____ GGBF Slag _____ Microsilica _____

Number of Aggregate Bins: Outside _____ Inside or Partially Enclosed _____

Number of Belt Conveyors that Discharge Aggregate into the Weigh Hopper: _____

Number of Bucket Elevators that Discharge Aggregate into the Weigh Hopper: _____

Type of Cement Conveyor to Weigh Hopper:

Bucket Elevator _____ Screw Conveyor _____ Air Slide _____ Pump _____

Type of Fly Ash Conveyor to Weigh Hopper:

Bucket Elevator _____ Screw Conveyor _____ Air Slide _____ Pump _____

Type of GGBF Slag Conveyor to Weigh Hopper:

Bucket Elevator _____ Screw Conveyor _____ Air Slide _____ Pump _____

Type of Microsilica Conveyor to Weigh Hopper:

Bucket Elevator _____ Screw Conveyor _____ Air Slide _____ Pump _____

Coarse Aggregate Stockpile Construction: Stationary Conveyor _____ Movable Conveyor _____
Truck _____ Clamshell _____ None _____

Fine Aggregate Stockpile Construction: Stationary Conveyor _____ Movable Conveyor _____
Truck _____ Clamshell _____ None _____

Coarse Aggregate Stockpile Separation Method: Dividers _____ Separated _____ None _____

Fine Aggregate Stockpile Separation Method: Dividers _____ Separated _____ None _____

Coarse Aggregate Moisture Sensor: Automatic _____ Manual _____ None _____

Fine Aggregate Moisture Sensor: Automatic _____ Manual _____ None _____

Water Measuring: Volume _____ Mass (Weight) _____
Water Source: City _____ Well _____ Pond _____

Hot Water: Yes _____ No _____ Chilled Water: Yes _____ No _____

Admixture Measuring: Volume _____ Mass (Weight) _____

Aggregate Heating: Space Heating Around Bins _____

Hot Water Through Coils in Bins _____

Steam Injection _____ Steam Pad _____ None _____

Recycled Material: Coarse Aggregate _____ Fine Aggregate _____ Water _____ None _____

Automatic Ticket Printer for English and Metric Units: Yes _____ No _____

General Comments: _____

Completed By: _____ / _____ of _____ on _____
(Print Name/Signature) (Company Name) (Date)

Approved By: _____ / _____ of District _____ on _____
(Print Name/Signature) (Number) (Date)
(FOR DEPARTMENT USE ONLY)

ILLINOIS DEPARTMENT OF TRANSPORTATION
ANNUAL INSPECTION CERTIFICATION FOR CONCRETE PLANT

Effective: March 1, 1997

Revised: January 1, 2002

Instructions: **Please type or print neatly.** Fill in the blanks or mark the item with an "X". The "Annual Inspection Certification for Concrete Plant" is submitted for the period which begins April 1st, and which expires the following year on March 31st.

Specifications:

The specifications for a concrete plant, as per the Standard Specifications for Road and Bridge Construction (January 1, 2002), are as follows:

Article 106.04Pages 23-24

Article 106.06Page 24

Article 106.07Page 24

Article 1020.10Page 874

Article 1020.11(c)...Pages 876-877

Article 1020.11(d)...Pages 877-881

Section 1103.....Pages 1126-1135

Other: Applicable Supplemental Specifications and Special Provisions

Applicant:

Company Name: _____

Company Address: _____

Company Phone Number: _____

Name & Title of Officer/Director of Company: _____

Plant Name: _____

Plant Location: _____

Inspection:

Name of Individual: _____

Company Name: _____

Company Address: _____

Company Phone Number: _____

NOTE: The inspection is normally performed by an employee of the applicant. However, an applicant may also desire plant certification by the National Ready Mixed Concrete Association (NRMCA). In this situation, the registered professional engineer hired by the applicant to do the NRMCA plant certification, may also perform the inspection required by IDOT.

If an individual from a scale company calibrates the plant scales only, it is not appropriate to indicate that this individual inspected the plant.

Certification:

I _____, certify the concrete plant indicated
 (Signature of Individual - Inspection)
 has been inspected on _____, and is according to
 (Date)
 specifications.

I _____, certify on _____,
 (Signature of Officer/Director - Applicant) (Date)
 the concrete plant indicated will be maintained according to specifications, and designate
 _____ to be contacted at _____ if a problem occurs.
 (Print Name of Designee) (Phone Number)

Additional Information:

A "Concrete Plant Survey" form is required and attached: Yes _____ No _____.

The plant scales were calibrated on _____.
 (date)

_____ of District _____ inspected the concrete plant on _____.
 (Print Name) (Number) (Date)

Approved By: _____ / _____ of District _____
 (Print Name/Signature) (Number)
 on _____. The time period is from _____ to _____.
 (Date) (Month/Day/Year) (Month/Day/Year)

(FOR DEPARTMENT USE ONLY)

ILLINOIS DEPARTMENT OF TRANSPORTATION
ANNUAL INSPECTION CERTIFICATION FOR CONCRETE DELIVERY TRUCKS

Effective: March 1, 1997

Revised: January 1, 2002

Instructions: **Please type or print neatly.** Fill in the blanks. The "Annual Inspection Certification for Concrete Delivery Trucks" is submitted for the period which begins April 1st, and which expires the following year on March 31st.

Specifications:

The specifications for each type of concrete delivery truck, as per the Standard Specifications for Road and Bridge Construction (January 1, 2002), are as follows:

Truck Mixers:

Article 1020.11(d)(2)Page 878

Article 1020.11(d)(6)Page 879

Article 1020.11(d)(7)Pages 879-880

Article 1103.01(b).....Pages 1127-1128

Other: Applicable Supplemental Specifications and Special Provisions

Truck Agitators

Article 1020.11(d)(4)Pages 878-879

Article 1020.11(d)(6)Page 879

Article 1020.11(d)(7)Pages 879-880

Article 1103.01(c)Page 1128

Other: Applicable Supplemental Specifications and Special Provisions

Nonagitator Trucks

Article 1103.01(d)Page 1128

Other: Applicable Supplemental Specifications and Special Provisions

Applicant:

Company Name: _____

Company Address: _____

Company Phone Number: _____

Name & Title of Officer/Director of Company: _____

Inspection:

Name of Individual: _____

Company Name: _____

Company Address: _____

Company Phone Number: _____

NOTE: The inspection is normally performed by an employee of the applicant. However, an applicant may also desire plant certification by the National Ready Mixed Concrete Association (NRMCA). In this situation, the registered professional engineer hired by the applicant to do the NRMCA plant certification, may also perform the inspection required by IDOT.

Certification:

I _____, certify the following concrete delivery
 (Signature of Individual - Inspection)
 trucks have been inspected on _____, and are according to
 (Date)
 specifications.

I _____, certify on _____,
 (Signature of Officer/Director-Applicant) (Date)
 the following concrete delivery trucks will be maintained according to specifications, and
 designate _____ to be contacted at _____ if a
 (Print Name of Designee) (Phone Number)
 problem occurs.

List of Concrete Delivery Trucks:

Truck No. or Designation of Acceptable Truck Mixers:

Truck No. or Designation of Acceptable Truck Agitators:

Truck No. or Designation of Acceptable Nonagitator Trucks:

_____ of District _____ inspected the concrete delivery
 (Print Name) (Number)
 trucks listed above on _____.
 (Date)

Approved By: _____ / _____ of District _____
 (Print Name/Signature) (Number)
 on _____. The time period is from _____ to _____
 (Date) (Month/Day/Year) (Month/Day/Year)

(FOR DEPARTMENT USE ONLY)

